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For: **BICYCLE STEM INCLUDING ENHANCED CLAMP AND ASSOCIATED METHODS**

Enclosed are:

- ☒ Patent Application: 39 pages, 76 claims.
- ☒ 7 Sheets of drawings.
- ☒ A Preliminary Amendment.
- ☒ Citation Under 37 CFR 1.97 and PTO-1449.
- ☒ Submission of Proposed Drawing Modification.

The Declaration and Filing Fee are **NOT ENCLOSED**.

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**BICYCLE STEM INCLUDING ENHANCED CLAMP  
AND ASSOCIATED METHODS**

**Related Application**

The present application is based upon  
provisional patent application serial no. 60/153,159  
filed on September 9, 1999, and the entire contents of  
5 which are incorporated herein by reference.

**Field of the Invention**

The present invention relates to the field of  
bicycles and bicycle components, and more particularly,  
to a bicycle stem for attaching a handlebar to a  
10 steering tube of a bicycle.

**Background of the Invention**

Bicycles are widely used for transportation  
and recreation. A typical bicycle includes a rear  
wheel carried by a frame and a front wheel carried by a  
15 fork which, in turn, is rotatably connected to a  
forward portion of the frame. In particular, a  
steering tube is connected at its lower end to the fork  
and extends through a corresponding passageway defined  
in the forward portion of the frame. An upper portion  
20 of the steering tube is connected to a bicycle stem.

The bicycle stem includes a steering tube  
clamping portion which clamps to the upper end of the

steering tube. A body portion extends generally forwardly and at an upward incline from the steering tube clamping portion and terminates at a handlebar clamping portion. The incline is generally upward for mountain biking and downward for road biking, as desired by the rider. Of course, the medial portion of the handlebar is connected to the handlebar clamping portion of the stem. The rider is thus able to steer the front wheel by turning the handlebar.

10           The stem is important for proper orientation and positioning of the rider relative to the bicycle. In addition, the stem is desirably relatively strong to avoid potentially catastrophic failure, and is also desirably lightweight to reduce the burden on the rider. Mountain or off-road biking can put especially high demands on the strength of the stem. Road bikes may also place high demands in terms of both required strength and being relatively lightweight on the bicycle stem.

20           The stem also desirably has relatively high torsional stiffness, that is, a resistance to allowing the handlebar to rotate as the rider pushes on one side while lifting on the other. If the torsional stiffness is too low, the rider's energy is more quickly and wastefully depleted in rotating the handlebar.

25           A widely used type of bicycle stem includes a body portion or tube and a steering tube clamp connected to an end of the body tube. The steering tube clamp is in the form of a split tube with a vertical slot opposite the body tube. One or typically two bolts or other fasteners are used to secure clamp together at the vertical slot. Unfortunately, the clamp and fasteners extend backward toward the rider and may present an object which the rider may strike or

bang with his knees, for example, such as during vigorous riding.

Another type of steering tube clamping arrangement attempts to remove the clamp and bolts from protruding backward into the rider's space. This type of stem includes a vertically oriented tubular portion defining a main passageway that receives the upper end of the steering tube. To secure the stem relative to the steering tube a clamp may be positioned within a second passageway that extends transverse to the main passageway and which is in communication with the main passageway. The clamp typically includes two cylindrical halves or clamping members which can be urged together by a single fastener, such as a bolt which extends along an axis defined by the cylindrical halves. More particularly, the cylindrical halves each include corresponding arcuate recesses which when properly aligned will press against an outer circumferential portion of the steering tube upon tightening of the bolt to thus clamp the bicycle stem to the steering tube. Such stems are shown, for example, in U.S. Patent Nos. 5,687,616 and 5,842,385.

Unfortunately, the transverse clamp for the steering tube has relatively little surface area to contact the steering tube. The outermost ends may define contact points which bite into the steering tube, thus forming dimples in the metal steering tube. Such deformations of the metal steering tube may be undesirable for a number of reasons. For example, the dimples may subsequent fine adjustment, since the clamp will tend to seat into the dimples. In addition, for a composite material steering tube an entirely different type of clamping arrangement may be needed to avoid causing damage in the composite material which may propagate to failure of the steering tube. Such

composite steering tubes are often used on high-end road bicycles, for example.

### **Summary of the Invention**

In view of the foregoing background, it is  
5 therefore an object of the invention to provide a bicycle stem and related methods wherein the clamp securely engages the steering tube without damaging the steering tube.

This and other objects, features and  
10 advantages in accordance with the present invention are provided by a bicycle stem comprising a steering tube clamp including a pair of cooperating clamp members aligned in side-by-side relation and comprising  
15 respective portions defining an imaginary cylinder and a recess therein for the steering tube, and wherein each clamp member may also have at least one fastener receiving passageway therein offset a predetermined distance from an axis defined by the imaginary cylinder. More particularly, the stem may include a  
20 body portion having opposing first and second ends, a handlebar clamping portion connected to the first end of the body portion, and a steering tube clamping portion connected to the second end of the body portion. The steering tube clamping portion may have a  
25 tubular shape defining a steering tube receiving passageway therethrough, and a clamp receiving passageway transverse to the steering tube passageway and in communication therewith.

The steering tube clamp is positioned in the  
30 clamp receiving passageway. The steering tube clamp may also include at least one fastener extending between corresponding fastener receiving passageways of the pair of clamp members for urging the clamp members together to engage the steering tube and thereby secure

the bicycle stem to the steering tube. The fastener receiving passageways may be offset the predetermined distance from the axis of the imaginary cylinder in a direction away from the recess. The positioning of the  
5 fastener receiving passageways, and, hence the one or more fasteners, in the offset relation from the axis of the imaginary cylinder allows the clamp to be more effective and rugged. For example, a greater extent of the steering tube can be engaged.

10 The body portion, handlebar clamping portion and steering tube clamping portion of the stem may be integrally formed as a monolithic unit, thereby also increasing strength especially relative to welded stems. In some embodiments, the at least one fastener  
15 comprises a plurality of fasteners. For example, the fasteners may comprise first and second bolts, each having an enlarged head and a threaded shaft extending outwardly therefrom. These first and second bolts may be positioned to extend in opposite directions. In  
20 other embodiments, only a single fastener may be used. In yet other embodiments, one of the steering tube clamp members may be integrally formed in a wall portion of the steering tube clamping portion, while the other steering tube clamp member is movable.

25 In accordance with another advantageous feature of the invention, the fastener receiving passageways may also be canted at a predetermined angle from parallel to the axis of the imaginary cylinder. This may allows the fasteners to be tightened with less  
30 likelihood of binding as outer portions of the clamp members engage the steering tube and tend to rotate.

In accordance with another advantageous feature of the present invention, the recess for the steering tube may extend for greater than a  
35 predetermined angle, such as greater than about 90, 120

or 180 degrees, for example. This also provides greater contact between the clamp members and the steering tube which, in turn, provides for greater holding power and a reduced likelihood of damaging the steering tube.

The pair of clamp members may each have a same shape which simplifies manufacturing, among other advantages. Each clamp member may also comprise an end having a circular shape, or a truncated circular shape.

A number of the advantageous features of the invention may be used independently or in combination. For example, the multiple fasteners may be used with or without the offset. The canting of the angle of the fastener receiving passageways and at least one fastener may also be used alone, or in combination with other features. The provision of the recess to extend greater than a predetermined angle, can also be used alone or in combination with other features.

The stem may further include a handlebar clamping member cooperating with the handlebar clamping portion to clamp the bicycle handlebar therebetween. The body portion of the stem may have a tubular hollow shape for reduced weight.

Other aspects of the invention relate to methods for making the bicycle stem. For example, one method comprises forming a body portion having opposing first and second ends, a handlebar clamping portion connected to the first end of the body portion, and a steering tube clamping portion connected to the second end of the body portion. The steering tube clamping portion may have a tubular shape defining a steering tube receiving passageway, and a clamp receiving passageway may be provided transverse to the steering tube passageway and in communication therewith.

The method may also include forming a steering tube clamp for positioning in the clamp receiving passageway. The steering tube clamp may include a pair of cooperating clamp members aligned in side-by-side relation and comprising respective portions defining an imaginary cylinder and a recess therein for the steering tube. Each clamp member may also have at least one fastener receiving passageway therein offset a predetermined distance from an axis defined by the imaginary cylinder. The clamp may further comprise at least one fastener extending between corresponding fastener receiving passageways of the pair of clamp members for urging the clamp members together to engage the steering tube and thereby secure the bicycle stem to the steering tube. Other methods for making the bicycle stem are also disclosed in greater detail below.

#### **Brief Description of the Drawings**

FIG. 1 is a perspective front view of a first embodiment of a bicycle stem in accordance with the present invention.

FIG. 2 is a left side elevational view of the stem as shown in FIG. 1.

FIG. 3 is a top plan view of the stem as shown in FIG. 1.

FIGS. 4 and 5 are perspective and side elevational views, respectively, of a steering tube clamp in accordance with the prior art.

FIGS. 6 and 7 are perspective and side elevational views, respectively, of an embodiment of a steering tube clamp in accordance with the present invention.

FIGS. 8 and 9 are perspective and side elevational views, respectively, of another embodiment



of a steering tube clamp in accordance with the present invention.

FIGS. 10, 11 and 12 are perspective, and side and elevational views, respectively, of the steering tube clamp as used in the stem of FIG. 1.

FIG. 13 is an end view of a variation of the steering tube clamp as shown in FIGS. 10-12.

FIGS. 14A and 14B are greatly enlarged longitudinal cross-sectional views of the steering tube clamp as shown in FIGS. 10-12 illustrating the canting angle feature.

FIGS. 15, 16 and 17 are left and right side elevational, and top plan views, respectively, of a portion of the steering tube clamping portion of another embodiment of the bicycle stem in accordance with the invention.

FIG. 18 is a perspective view of an embodiment of a steering tube clamp member to be used in the bicycle stem embodiment shown in FIGS. 15-17.

FIG. 19 is a greatly enlarged cross-sectional view taken through the handlebar clamping portion and handlebar clamping member of the bicycle stem as shown in FIG. 1.

FIGS. 20 and 21 are perspective and end views, respectively, of the handlebar clamping portion of the bicycle stem as shown in FIG. 1 with the handlebar clamp removed for clarity.

FIGS. 22 and 23 are top plan and bottom plan views, respectively, of the handlebar clamp member as shown in FIG. 1.

FIGS. 24 and 25 are side and end elevational views, respectively, of the handlebar clamp member as shown in FIG. 1.

FIGS. 26 and 27 are left and right side elevational views of the steering tube portion of the

bicycle stem as shown in FIG. 1 illustrating the maintenance failure indication.

FIG. 28 is a bottom plan view of the bicycle stem as shown in FIGS. 26 and 27.

5      **Detailed Description of the Preferred Embodiments**

The present invention now will be described more fully hereinafter with reference to the accompanying drawings, in which preferred embodiments of the invention are shown. This invention may, however, be embodied in many different forms and should not be construed as limited to the embodiments set forth herein. Rather, these embodiments are provided so that this disclosure will be thorough and complete, and will fully convey the scope of the invention to those skilled in the art. Like numbers refer to like elements throughout. Prime and multiple prime notation are used to indicate similar elements in alternate embodiments.

Referring initially to FIGS. 1-3, a first embodiment of the bicycle stem **30** in accordance with the invention is now described. The bicycle stem **30** illustratively includes a body portion **31** having opposing first and second ends, a handlebar clamping portion **32** connected to the first end of the body portion, and a steering tube clamping portion **33** connected to the second end of the body portion. A handlebar clamping member **50** is removably secured to the handlebar clamping portion **32** as will be described below in greater detail.

In the illustrated stem **30** the body portion **31** is angled upwardly from the steering tube clamping portion **33**. The stem **30** may be reversed when connected to a bicycle so that the body portion **31** angles

downwardly from the steering tube clamping portion **33**  
as will be appreciated by those skilled in the art.  
For example, for mountain biking many riders may prefer  
the upward angle, while road bikers may prefer the  
5 downward arrangement.

In the illustrated embodiment, the body  
portion **31** has a tubular construction for reduced  
weight with a progressively increasing diameter from  
the first to the second ends. Of course, in other  
10 embodiments, the body portion **31** of the stem **30** could  
be made shorter or longer, and the body portion **31**  
could be perpendicular to the steering tube clamping  
portion **33**. The body portion **31** could also have a  
constant diameter, or have other shapes, such as a  
15 block shape, as will also be appreciated by those  
skilled in the art.

The steering tube clamping portion **33**  
illustratively has a tubular shape defining a steering  
tube receiving passageway therethrough **35**, and a clamp  
20 receiving passageway **36** (FIGS. 1 and 3) transverse to  
the steering tube receiving passageway and in  
communication therewith. By tubular is meant side  
walls having an opening or bore therein defining the  
steering tube receiving passageway **35**, and the side  
25 walls need not have a uniform thickness in all  
contemplated embodiments. In some embodiments, the  
steering tube clamping portion **33**, could have a  
rectangular, polygonal or other shape and still be  
considered as tubular as will be appreciated by those  
30 skilled in the art.

The steering tube clamping portion **33**  
desirably presents a smooth surface free of protrusions  
in the direction backward toward the rider. As  
discussed above in the Background, such protrusions as

are common on many conventional stems may be contacted by a knee of a rider.

The body portion **31**, handlebar clamping portion **32** and steering tube clamping portion **33** of the stem **30** may be integrally formed as a monolithic unit in some embodiments, thereby also increasing strength especially relative to welded stems. The material may be a metal, such as aluminum, magnesium, steel, or alloys thereof, or the material may be a plastic or composite material, such as carbon fiber, as will be appreciated by those skilled in the art.

Referring now additionally to FIGS. 4-12, embodiments and aspects of the steering tube clamp **40** are now described. A prior art steering tube clamp **140** is shown in FIGS. 4 and 5 and includes a pair of cooperating clamp members **141a**, **141b** aligned in side-by-side relation. The prior art steering tube clamp **140** also includes respective portions defining an imaginary cylinder, and a recess, defined by respective recesses **143a**, **143b**, for the steering tube. Each clamp member **141a**, **141b** also has a fastener receiving passageway **142a**, **142b** therein to receive a single fastener, such as a bolt, for example. The fastener receiving passageways **142a**, **142b** are aligned along the axis **145** defined by the imaginary cylinder.

This prior art arrangement of the fastener receiving passageways **142a**, **142b** along the axis **145** results in a relatively shallow recess provided by the combination of recesses **143a**, **143b**. For example, this shallow arrangement may provide contact of one recess **143a** of less than about 40 degrees for the angle **A** as shown in FIG. 5. The total clamp contact onto the steering tube is then less than about 80 degrees. This

may result in a weak connection to the steering tube and/or damage to the steering tube, for example.

As shown in the embodiments of the invention in FIGS. 6-12, the stem **30** in some embodiments  
5 advantageously includes a steering tube clamp **40**, **40'** **40"** with cooperating clamp members **41a**, **41b**; **41a'**, **41b'**; **41a"**, **41b"** aligned in side-by-side relation and comprising respective portions defining an imaginary cylinder and a recess therein for the steering tube.  
10 The recesses are defined by the individual recesses **43a**, **43b**; **43a'**, **43b'**; **43a"**, **43b"** as will be appreciated by those skilled in the art. Moreover, each clamp member **41a**, **41b**; **41a'**, **41b'**; **41a"**, **41b"** also has at least one fastener receiving passageway therein **42a**,  
15 **42b**, **42c**, **42d**; **43a'**, **43b'**; **43a"**, **43b"** offset a predetermined distance from an axis **45**, **45'**, **45"** defined by the imaginary cylinder.

The arrangement of the offset is also illustratively in the direction away from the recess  
20 for the steering tube. This configuration provides for a greater area and/or angle of contact between the steering tube clamp **40**, **40'** **40"** and the steering tube. Many of the disadvantages of the prior art steering tube clamp **140** are overcome in accordance with this  
25 aspect of the present invention.

The offset may range from several millimeters to 10 or more millimeters depending on the size of the steering tube and other considerations as will be appreciated by those skilled in the art. The offset  
30 permits the angle of contact provided by a recess of a clamp member to be greater than about 45 degrees in some embodiments, greater than about 60 degrees in other embodiments, and even greater than 90 degrees in other preferred embodiments. In other words, the

recesses may be greater than 90, 120 and even 180 degrees. While prior art clamps **140** may have had a tendency to damage or deform the steering tube from proper roundness, the steering tube clamp **40, 40', 40"**  
5 in accordance with the invention may actually enhance the roundness of a steering tube that is out of round, such as caused by prior use of a conventional steering tube clamp **140**, or from a tube that is out-of-round from the factory.

10 Referring now more particularly to FIGS. 6 and 7, the steering tube clamp **40'** includes only a single pair of aligned fastener receiving passageways **42a', 42b'** to receive a single fastener, such as a bolt, not shown. In other words, one of the fastener  
15 receiving passageways may be threaded and the other may include a stepped diameter to accommodate the enlarged bolt head as will be appreciated by those skilled in the art. Other types of the fastener are also contemplated by the present invention.

20 In this embodiment of the steering tube clamp **40'** the ends of the clamp members **41a', 41b'** may be considered as defining circles. Thus the imaginary cylinder defined by the steering tube clamp members **41a', 41b'** is essentially a circular cylinder defined  
25 by the perimeter portions of the ends of the clamp members in the illustrated embodiment. A relatively large contact angle **B** is thus defined by the steering tube clamp members **41a', 41b'**. Other forms of imaginary cylinders are also contemplated by the  
30 present invention, including those having a cross-sectional shape in the form of a rectangle, square, ellipse, and/or polygon, or other shape, as long as such a shape defines an axis from which the fastener receiving passageways are offset.

Referring now more particularly, to the steering tube clamp **40**" shown in FIGS. 8 and 9, another embodiment or variation is explained. In this variation, end portions of the clamp members **41a"**, **41b"** are each cut or truncated along a plane intersecting the imaginary cylinder as will be readily appreciated by those skilled in the art. In other words, cut-off wing portions are formed at the ends of the clamp members **41a"**, **41b"**. A somewhat smaller contact angle **C** is provided as compared to the steering tube clamp embodiment **40'** discussed above with reference to FIGS. 6 and 7, however, the available contact angle **C** is still greater than the angle **A** of the prior art steering tube clamp **140**.

Referring now briefly again to FIGS. 10-12, this embodiment of the steering tube clamp **40** is similar to the embodiment of the steering tube clamp **40'** shown in FIGS. 6 and 7. The steering tube clamp **40** has a profiled shape on the outer end surfaces of each clamp member **41a**, **41b** to match the curvature of the adjacent portions of the steering tube clamping portion **33** as perhaps best seen in FIG. 1.

In addition, the steering tube clamp **40** includes two fasteners, in the form of bolts **46a**, **46b** (FIG. 10) arranged in opposite directions. Each bolt **46a**, **46b** may have an enlarged head and a threaded shaft extending outwardly therefrom. The head may include a recess extending inwardly from an end surface that is keyed, such as to permit turning via an Allen or Torx tool, for example.

In other embodiments, more than two fasteners may be used, and their directions need not be opposing. The dual bolt opposing arrangement does provide some advantages in terms of symmetry, ease of manufacture,

and perhaps easier tightening of the fasteners as will be appreciated by those skilled in the art. Of course, using a plurality of fasteners may provide greater holding strength, as well as provide redundancy in the event one of the fasteners fails, becomes loose, or is not properly tightened initially

Referring briefly to FIG. 13, a variation of the steering tube clamp **40'''** is shown in end view, wherein end portions are truncated along a plane parallel to the axis **45'''**. This is similar to the steering tube clamping member **40''** shown in FIGS. 8 and 9. The dual fasteners **46a'''**, **46b'''** are also similar to the steering tube clamp **40** shown in FIGS. 10-12. Accordingly, the steering tube clamp **40'''** needs no further description herein.

Referring to FIG. 11 and additionally to the enlarged and exaggerated cross-sectional views of FIGS. 14A and 14B, yet another advantageous aspect of the steering tube clamp **40** of the bicycle stem **30** is described. As shown in FIG. 14A, the steering tube clamp **40** illustratively includes a set of fastener receiving passageways **42b**, **42c** which are canted at a predetermined angle **D** from parallel to the axis **45** of the imaginary cylinder. The dashed line **49** indicates a parallel line to the axis **45**. In other words, in the position shown in FIG. 14A, the passageways **42b**, **42c** define a shallow V-shape.

This canting allows the fasteners to be tightened with less likelihood of binding as outer portions of the clamp members **41a**, **41b** engage the steering tube and tend to rotate the outer portions of the clamp members outwardly as the lower portions of the clamp members themselves are being drawn together as shown in FIG. 14B. In the illustrated embodiment,



the fastener is in the form of a bolt **46b** having an enlarged head **47b** and a threaded shaft **48b** extending outwardly therefrom. A keyed recess **49b** is provided in the end of the bolt head **47b**.

5               For example, the predetermined angle **D** may be in a range of about one-half to five degrees and, more preferably about one to three degrees. One and one-half degrees for the canting angle **D** has also been found satisfactory for some embodiments. Although two  
10 sets of fastener receiving passageways are shown in the embodiment of the steering tube clamp **40**, this canting concept is applicable to a single set or more than two sets.

              The same or equivalent effect to canting the  
15 fastener receiving passageways at the predetermined angle **D** may be achieved by changing the outer shape of the clamping members **41a**, **41b** to be canted as will be appreciated by those skilled in the art.

              As will be readily appreciated by those  
20 skilled in the art, a number of the advantageous features of the invention may be used independently or in combination. For example, the multiple fasteners may be used with or without the offset. The canting of the angle of the fastener receiving passageways may  
25 also be used alone, or in combination with other features. The provision of the recess to extend greater than a predetermined angular amount, can also be used alone or in combination with other features.

              Turning now to FIGS. 15-18, another variation  
30 of the bicycle stem **30'** is now described. In this variation, only a single movable clamping member **41a'** is used, and the other mating clamping member is in effect provided by integrally formed opposing wall portions **41b'** of the steering tube clamping portion

**33'**. The movable clamp member may be either on the right or lefthand side as will be appreciated by those of skill in the art. Of course, these opposing wall portions **41b'** would also include the fastener receiving passageways **42b'**, **42d'** as shown in the illustrated embodiment, and as will be appreciated by those skilled in the art.

In this embodiment, the clamping member **41a'** is like the clamping member **41a** used in the steering tube clamp **40** as shown in FIGS. 10-12. In other embodiments, the clamping member could have other configurations as also described herein. Accordingly, the clamping member **41a'** needs no further description, nor do the other elements of the stem **30'** shown in FIGS. 15-18.

Turning now to FIGS. 19 to 25 other advantageous features of the stem **30** are further described, particularly as relating to the handlebar clamping portion **32** and its associated handlebar clamp member **50**. In particular, a conventional handlebar **60** as illustrated includes a pair of nominal diameter tubular portions **61a**, **61b** connected together at a central gripping or clamping portion **62**. Moreover, the gripping or clamping portion **62** may be tapered, such as to present an enlarged diameter or slightly larger diameter portion **63** at a medial position thereof. Attempting to clamp uniformly across the entire extent of the tapered or enlarged diameter portion **63** may present difficulties, and strength and/or torsional rigidity of the stem may then be compromised.

The illustrated stem **30** includes the handlebar clamping member **50** which cooperates with the handlebar clamping portion **33** to clamp the bicycle

handlebar **60** therebetween. The handlebar clamping member **50** may be secured by one or more removable fasteners so as to be completely removable from the handlebar clamping portion **32** in some embodiments, to  
5 thereby facilitate installation of the handlebar **60**.

In some prior art stems, the handlebar clamp is defined by a single slot in a tube that can be slightly opened to receive the handlebar. Unfortunately, the handlebar must then be carefully and  
10 painstakingly threaded through the small opening. In addition, hardware attached to the handlebar may need to be removed from the handlebar. Accordingly, one advantageous feature of the illustrated stem **30** is that the clamping member **50** may be completely removed to  
15 facilitate installation of the handlebar.

The handlebar clamping member **50** and the handlebar clamping portion **32** have respective cavities **53**, **52** in respective medial portions thereof to accommodate the enlarged diameter medial portion **63** of  
20 the handlebar **60**. The handlebar clamping member **50** in the illustrated embodiment has a generally rectangular shape with a semi-cylindrical recess **70** (see, e.g. FIG. 24) formed therein for receiving and engaging the handlebar **60**. The semi-cylindrical recess **70** and  
25 medial cavity **63** thus define two arcuate contact bands or areas **63a**, **63b** for tightly engaging the handlebar **60** at spaced apart locations. Indeed these spaced apart contact bands **63a**, **63b** illustratively extend to the outer edges of the stem **30**. Similarly, the handlebar  
30 clamping portion **32** illustratively includes a semi-cylindrical recess therein, which, in combination with its medial cavity **53**, defines a corresponding pair of arcuate contact bands or areas **63a**, **63b** which are also

spaced from one another to the edges of the stem **30**.  
Accordingly, a rigid and strong connection can be made  
from the stem **30** to the handlebar **60**, such as to reduce  
torsional rotation during riding, which would otherwise  
5 occur to sap the rider's energy.

In the illustrated embodiment, the body  
portion **31** has a tubular shape with a hollow interior  
**66**. The cavity **53** of the handlebar clamping portion **32**  
has an opening therein in communication with the hollow  
10 interior **66** of the body portion. Accordingly, weight  
can be reduced without compromising strength.

The handlebar clamping member **50** and the  
handlebar clamping portion **32** may both have generally  
rectangular shapes overlying one another. In these  
15 embodiments, respective fasteners **67a-67d** (FIG. 22)  
secure the corners of the handlebar clamping member **50**  
and the handlebar clamping portion **32** together. The  
handlebar clamping portion **32** may include threaded  
passageways, and the handlebar clamping member **50** may  
20 include corresponding passageways, including enlarged  
portions to receive the bolt heads as shown in the  
illustrated embodiment. Of course, this configuration  
of fasteners **67a-67d** could be reversed. Fewer or  
greater than four fasteners could also be used in other  
25 embodiments. In addition, the cavities **53**, **52** may be  
advantageously used in stem configurations, such as the  
single slot handlebar clamp stem discussed above, and  
others, as will be appreciated by those skilled in the  
art.

30 Turning now additionally to FIGS. 26 to 28  
another aspect of the stem **30** in accordance with the  
invention is now described. In accordance with this  
aspect, the bicycle stem **30** comprises a body portion  
**31**, a handlebar clamping portion **32** (FIGS. 1-3) and a

steering tube clamping portion **33** having relative strengths so that a predetermined portion, such as a leg **70a** of the steering tube clamping portion **32**, will crack first to thereby provide a visual maintenance  
5 indication to a user. As described above the steering tube clamping portion **32** may have a tubular shape defining a steering tube receiving passageway **35** therethrough. The clamp receiving passageway **36** is transverse to the steering tube passageway **35** and in  
10 communication therewith. The steering tube clamping portion **32** may thus comprise four legs **70a-70d** defined by the steering tube receiving passageway **35** and the clamp receiving passageway **36**.

The relative strengths may be configured so  
15 that one of the legs, typically a lower leg, such as the illustrated lower leg **70a** will form a crack **75** first. Of course, the crack **75** provides a visual indication to the user to repair or replace the stem **30**. The other three legs **70b-70d** are preferably  
20 sufficiently strong to maintain a connection to the steering tube even with one of the legs cracked. Thus the likelihood of unexpected complete or catastrophic failure of the stem is significantly reduced.

By forming a crack **75** first is generally  
25 intended to mean forming a crack based upon material fatigue, as opposed, for example, to ultimate breaking strength. Fatigue is typically more of a problem as a bicycle is used over and over again with the rider providing alternating rotational loads on the  
30 handlebar. For example, an aluminum embodiment of the stem **30** has been tested to withstand upwards of 80,000 load cycles before the first leg will crack. The test included providing alternating loads of  $\pm 92$  pounds of force on a test handlebar spanning eighteen inches from

end-to-end, and with the stem in the middle. It is further noted that the torsional rigidity of the stem 30 is also very high. For example, greater than 100 foot-pounds of torque may be needed for a one degree  
5 deflection of the handlebar.

Although the invention is directed primarily to a bicycle stem, the same or similar concepts are also applicable to connection from one body or device to a tube, rod or bar. For example, the steering tube  
10 clamp concepts can be readily extended to any such connections where it is desired to clamp to a tube or solid round bar or rod, for example. Accordingly, many modifications and other embodiments of the invention will come to the mind of one skilled in the art.

15 In addition, other features relating to the bicycle stem are disclosed in copending patent applications filed concurrently herewith and assigned to the assignee of the present invention and are entitled BICYCLE STEM FOR ENLARGED HANDLEBAR PORTIONS  
20 AND ASSOCIATED METHODS, having attorney work docket number 57012; BICYCLE STEM HAVING VISUAL MAINTENANCE INDICATION AND ASSOCIATED METHODS, attorney work docket number 57013; and OBJECT CLAMP INCLUDING CLAMP MEMBERS AND ASSOCIATED METHODS, attorney work docket number  
25 57014; the entire disclosures of which are incorporated herein in their entirety by reference. Therefore, it is to be understood that the invention is not to be limited to the specific embodiments disclosed, and that other modifications and embodiments are intended to be  
30 included within the scope of the appended claims.

**THAT WHICH IS CLAIMED IS:**

1. A bicycle stem for connecting a bicycle handlebar to a bicycle steering tube, the bicycle stem comprising:

- 5 a body portion having opposing first and second ends;
- a handlebar clamping portion connected to the first end of said body portion;
- a steering tube clamping portion connected to the second end of said body portion and having a
- 10 tubular shape defining a steering tube receiving passageway therethrough, said steering tube clamping portion also having a clamp receiving passageway therein transverse to the steering tube receiving passageway and in communication therewith;
- 15 a steering tube clamp in the clamp receiving passageway and comprising
  - a pair of cooperating clamp members
  - aligned in side-by-side relation and
  - comprising respective portions defining an
  - 20 imaginary cylinder and a recess therein for the steering tube, each clamp member also having at least one fastener receiving passageway therein offset a predetermined distance from an axis defined by the
  - 25 imaginary cylinder, and
  - at least one fastener extending between corresponding fastener receiving passageways of said pair of clamp members for urging said clamp members together to engage the steering
  - 30 tube and thereby secure the bicycle stem to the steering tube.

2. A bicycle stem according to Claim 1 wherein said fastener receiving passageways are offset the predetermined distance from the axis of the imaginary cylinder in a direction away from the recess.

3. A bicycle stem according to Claim 1 wherein said body portion, handlebar clamping portion and steering tube clamping portion are integrally formed as a monolithic unit.

4. A bicycle stem according to Claim 1 wherein said at least one fastener comprises a plurality of fasteners.

5. A bicycle stem according to Claim 4 wherein said plurality of fasteners comprises first and second bolts, each having an enlarged head and a threaded shaft extending outwardly therefrom.

6. A bicycle stem according to Claim 5 wherein said first and second bolts extend in opposite directions.

7. A bicycle stem according to Claim 1 wherein said at least one fastener comprises a single fastener.

8. A bicycle stem according to Claim 1 wherein said fastener receiving passageways are also canted at a predetermined angle from parallel to the axis of the imaginary cylinder.

9. A bicycle stem according to Claim 8 wherein the predetermined angle is in a range of about one-half to five degrees.



10. A bicycle stem according to Claim 1 wherein the recess for the steering tube extends for greater than a predetermined angle.

11. A bicycle stem according to Claim 10 wherein the recess for the steering tube extends for greater than about 90 degrees.

12. A bicycle stem according to Claim 1 wherein said pair of clamp members each have a same shape.

13. A bicycle stem according to Claim 1 wherein each clamp member comprises an end having a circular shape.

14. A bicycle stem according to Claim 1 wherein each clamp member comprises an end having a truncated circular shape.

15. A bicycle stem according to Claim 1 further comprising a handlebar clamping member cooperating with said handlebar clamping portion to clamp the bicycle handlebar therebetween.

16. A bicycle stem according to Claim 1 wherein a first clamp member is integrally formed with a side wall portion of said steering tube clamping portion, and wherein a second clamp member is movable  
5 relative to the first clamp member.

17. A bicycle stem for connecting a bicycle handlebar to a bicycle steering tube, the bicycle stem comprising:

a body portion having opposing first and  
5 second ends;

a handlebar clamping portion connected to the  
first end of said body portion;

a steering tube clamping portion connected to  
the second end of said body portion and having a  
10 tubular shape defining a steering tube receiving  
passageway therethrough, said steering tube clamping  
portion also having a clamp receiving passageway  
therein transverse to the steering tube receiving  
passageway and in communication therewith;

15 a steering tube clamp in the clamp receiving  
passageway and comprising

a pair of cooperating clamp members  
aligned in side-by-side relation and  
comprising respective portions defining an  
20 imaginary cylinder and a recess therein for  
the steering tube, each clamp member also  
having at least one fastener receiving  
passageway therein offset a predetermined  
distance from an axis defined by the  
25 imaginary cylinder in a direction away from  
the recess, and

at least one fastener extending between  
corresponding fastener receiving passageways  
of said pair of clamp members for urging said  
30 clamp members together to engage the steering  
tube and thereby secure the bicycle stem to  
the steering tube;

said body portion, handlebar clamping portion  
and steering tube clamping portion being integrally  
35 formed as a monolithic unit.

18. A bicycle stem according to Claim 17 wherein said at least one fastener comprises a plurality of fasteners.

19. A bicycle stem according to Claim 17 wherein said fastener receiving passageways are also canted at a predetermined angle from parallel to the axis of the imaginary cylinder.

20. A bicycle stem according to Claim 17 wherein the recess for the steering tube extends for greater than a predetermined angle.

21. A bicycle stem according to Claim 17 wherein said pair of clamp members each have a same shape.

22. A bicycle stem according to Claim 17 further comprising a handlebar clamping member cooperating with said handlebar clamping portion to clamp the bicycle handlebar therebetween.

23. A bicycle stem according to Claim 17 wherein a first clamp member is integrally formed with a side wall portion of said steering tube clamping portion, and wherein a second clamp member is movable  
5 relative to the first clamp member.

24. A bicycle stem for connecting a bicycle handlebar to a bicycle steering tube, the bicycle stem comprising:

a body portion having opposing first and  
5 second ends;

a handlebar clamping portion connected to the first end of said body portion;

10 a steering tube clamping portion connected to  
the second end of said body portion and having a  
tubular shape defining a steering tube receiving  
passageway therethrough, said steering tube clamping  
portion also having a clamp receiving passageway  
therein transverse to the steering tube receiving  
passageway and in communication therewith;

15 a steering tube clamp in the clamp receiving  
passageway and comprising

20 a pair of cooperating clamp members  
aligned in side-by-side relation and  
comprising respective portions defining a  
recess therein for the steering tube, each  
clamp member having a plurality of fastener  
receiving passageways therein, and

25 a plurality of fasteners extending  
between corresponding fastener receiving  
passageways of said pair of clamp members for  
urging said clamp members together to engage  
the steering tube and thereby secure the  
bicycle stem to the steering tube.

25. A bicycle stem according to Claim 24  
wherein said plurality of fasteners comprises first and  
second bolts, each having an enlarged head and a  
threaded shaft extending outwardly therefrom.

26. A bicycle stem according to Claim 25  
wherein said first and second bolts extend in opposite  
directions.

27. A bicycle stem according to Claim 24  
wherein said body portion, handlebar clamping portion  
and steering tube clamping portion are integrally  
formed as a monolithic unit.

28. A bicycle stem according to Claim 24 wherein said clamp members also comprise portions defining an imaginary cylinder; and wherein the fastener receiving passageways are also canted at a  
5 predetermined angle from parallel to an axis of the imaginary cylinder.

29. A bicycle stem according to Claim 24 wherein the recess for the steering tube extends for greater than a predetermined angle.

30. A bicycle stem according to Claim 24 wherein said pair of clamp members each have a same shape.

31. A bicycle stem according to Claim 24 further comprising a handlebar clamping member cooperating with said handlebar clamping portion to clamp the bicycle handlebar therebetween.

32. A bicycle stem according to Claim 24 wherein a first clamp member is integrally formed with a side wall portion of said steering tube clamping portion, and wherein a second clamp member is movable  
5 relative to the first clamp member.

33. A bicycle stem for connecting a bicycle handlebar to a bicycle steering tube, the bicycle stem comprising:

a body portion having opposing first and  
5 second ends;

a handlebar clamping portion connected to the first end of said body portion;

a steering tube clamping portion connected to the second end of said body portion and having a

- 10 tubular shape defining a steering tube receiving  
passageway therethrough, said steering tube clamping  
portion also having a clamp receiving passageway  
therein transverse to the steering tube receiving  
passageway and in communication therewith;
- 15 a steering tube clamp in the clamp receiving  
passageway and comprising
- a pair of cooperating clamp members  
aligned in side-by-side relation and  
comprising respective portions defining an  
20 imaginary cylinder and a recess therein for  
the steering tube, each clamp member also  
having at least one fastener receiving  
passageway therein canted at a predetermined  
angle from parallel to an axis of the  
25 imaginary cylinder, and
- at least one fastener extending between  
corresponding fastener receiving passageways  
of said pair of clamp members for urging said  
clamp members together to engage the steering  
30 tube and thereby secure the bicycle stem to  
the steering tube.

34. A bicycle stem according to Claim 33  
wherein the predetermined angle is in a range of about  
one-half to five degrees.

35. A bicycle stem according to Claim 33  
wherein said body portion, handlebar clamping portion  
and steering tube clamping portion are integrally  
formed as a monolithic unit.

36. A bicycle stem according to Claim 33  
wherein the recess for the steering tube extends for  
greater than a predetermined angle.

37. A bicycle stem according to Claim 33 wherein said pair of clamp members each have a same shape.

38. A bicycle stem according to Claim 33 further comprising a handlebar clamping member cooperating with said handlebar clamping portion to clamp the bicycle handlebar therebetween.

39. A bicycle stem according to Claim 33 wherein a first clamp member is integrally formed with a side wall portion of said steering tube clamping portion, and wherein a second clamp member is movable  
5 relative to the first clamp member.

40. A bicycle stem for connecting a bicycle handlebar to a bicycle steering tube, the bicycle stem comprising:

- 5 a body portion having opposing first and second ends;
- a handlebar clamping portion connected to the first end of said body portion;
- a steering tube clamping portion connected to the second end of said body portion and having a  
10 tubular shape defining a steering tube receiving passageway therethrough, said steering tube clamping portion also having a clamp receiving passageway therein transverse to the steering tube receiving passageway and in communication therewith;
- 15 a steering tube clamp in the clamp receiving passageway and comprising
  - a pair of cooperating clamp members aligned in side-by-side relation and comprising respective portions defining a  
20 recess therein for the steering tube, the

recess extending for greater than about 90 degrees, and each clamp member having at least one fastener receiving passageway therein, and

25                   at least one fastener extending between corresponding fastener receiving passageways of said pair of clamp members for urging said clamp members together to engage the steering tube and thereby secure the bicycle stem to  
30                   the steering tube.

41. A bicycle stem according to Claim 40 wherein the recess extends for greater than about 120 degrees.

42. A bicycle stem according to Claim 40 wherein the recess extends for greater than about 180 degrees.

43. A bicycle stem according to Claim 40 wherein said body portion, handlebar clamping portion and steering tube clamping portion are integrally formed as a monolithic unit.

44. A bicycle stem according to Claim 40 wherein said pair of clamp members each have a same shape.

45. A bicycle stem according to Claim 40 further comprising a handlebar clamping member cooperating with said handlebar clamping portion to clamp the bicycle handlebar therebetween.

46. A bicycle stem according to Claim 40 wherein a first clamp member is integrally formed with



a side wall portion of said steering tube clamping  
portion, and wherein a second clamp member is movable  
5 relative to the first clamp member.

47. A method for making a bicycle stem for  
connecting a bicycle handlebar to a bicycle steering  
tube, the method comprising:

forming a body portion having opposing first  
5 and second ends, a handlebar clamping portion connected  
to the first end of the body portion, and a steering  
tube clamping portion connected to the second end of  
the body portion, the steering tube clamping portion  
having a tubular shape defining a steering tube  
10 receiving passageway therethrough and a clamp receiving  
passageway therein transverse to the steering tube  
receiving passageway and in communication therewith;

forming a steering tube clamp for positioning  
in the clamp receiving passageway and comprising  
15 a pair of cooperating clamp members  
aligned in side-by-side relation and  
comprising respective portions defining an  
imaginary cylinder and a recess therein for  
the steering tube, each clamp member also  
20 having at least one fastener receiving  
passageway therein offset a predetermined  
distance from an axis defined by the  
imaginary cylinder, and

at least one fastener extending between  
25 corresponding fastener receiving passageways  
of the pair of clamp members for urging the  
clamp members together to engage the steering  
tube and thereby secure the bicycle stem to  
the steering tube.

48. A method according to Claim 47 wherein the fastener receiving passageways are offset the predetermined distance from the axis of the imaginary cylinder in a direction away from the recess.

49. A method according to Claim 47 wherein the body portion, handlebar clamping portion and steering tube clamping portion are integrally formed as a monolithic unit.

50. A method according to Claim 47 wherein the at least one fastener comprises a plurality of fasteners.

51. A method according to Claim 47 wherein the fastener receiving passageways are also canted at a predetermined angle from parallel to the axis of the imaginary cylinder.

52. A method according to Claim 47 wherein the recess for the steering tube extends for greater than a predetermined angle.

53. A method according to Claim 47 wherein the pair of clamp members each have a same shape.

54. A method according to Claim 47 further comprising forming a handlebar clamping member to cooperate with the handlebar clamping portion to clamp the bicycle handlebar therebetween.

55. A method according to Claim 45 wherein forming the steering tube clamp comprises integrally forming a first clamp member with a side wall portion of the steering tube clamping portion.

56. A method for making a bicycle stem for connecting a bicycle handlebar to a bicycle steering tube, the method comprising:

forming a body portion having opposing first  
5 and second ends, a handlebar clamping portion connected to the first end of the body portion, and a steering tube clamping portion connected to the second end of the body portion, the steering tube clamping portion having a tubular shape defining a steering tube  
10 receiving passageway therethrough and a clamp receiving passageway therein transverse to the steering tube receiving passageway and in communication therewith;  
forming a steering tube clamp for positioning in the clamp receiving passageway and comprising  
15 a pair of cooperating clamp members aligned in side-by-side relation and comprising respective portions defining a recess therein for the steering tube, each clamp member having a plurality of fastener  
20 receiving passageways therein, and  
a plurality of fasteners extending between corresponding fastener receiving passageways of the pair of clamp members for urging the clamp members together to engage  
25 the steering tube and thereby secure the bicycle stem to the steering tube.

57. A method according to Claim 56 wherein the plurality of fasteners comprises first and second bolts, each having an enlarged head and a threaded shaft extending outwardly therefrom.

58. A method according to Claim 57 wherein the first and second bolts extend in opposite directions.

59. A method according to Claim 56 wherein the body portion, handlebar clamping portion and steering tube clamping portion are integrally formed as a monolithic unit.

60. A method according to Claim 56 wherein the pair of clamp members each have a same shape.

61. A method according to Claim 56 further comprising forming a handlebar clamping member to cooperate with the handlebar clamping portion to clamp the bicycle handlebar therebetween.

62. A method according to Claim 56 wherein forming the steering tube clamp comprises integrally forming a first clamp member with a side wall portion of the steering tube clamping portion.

63. A method for making a bicycle stem for connecting a bicycle handlebar to a bicycle steering tube, the method comprising:

forming a body portion having opposing first  
5 and second ends, a handlebar clamping portion connected  
to the first end of the body portion, and a steering  
tube clamping portion connected to the second end of  
the body portion, the steering tube clamping portion  
having a tubular shape defining a steering tube  
10 receiving passageway therethrough and a clamp receiving  
passageway therein transverse to the steering tube  
receiving passageway and in communication therewith;

forming a steering tube clamp for positioning  
in the clamp receiving passageway and comprising

15           a pair of cooperating clamp members  
aligned in side-by-side relation and  
comprising respective portions defining an  
imaginary cylinder and a recess therein for  
the steering tube, each clamp member also  
20           having at least one fastener receiving  
passageway therein canted at a predetermined  
angle from parallel to an axis of the  
imaginary cylinder, and

25           at least one fastener extending between  
corresponding fastener receiving passageways  
of the pair of clamp members for urging the  
clamp members together to engage the steering  
tube and thereby secure the bicycle stem to  
the steering tube.

64. A method according to Claim 63 wherein  
the predetermined angle is in a range of about one-half  
to five degrees.

65. A method according to Claim 63 wherein  
the body portion, handlebar clamping portion and  
steering tube clamping portion are integrally formed as  
a monolithic unit.

66. A method according to Claim 63 wherein  
the recess for the steering tube extends for greater  
than a predetermined angle.

67. A method according to Claim 63 wherein  
the pair of clamp members each have a same shape.

68. A method according to Claim 63 further comprising forming a handlebar clamping member to cooperate with the handlebar clamping portion to clamp the bicycle handlebar therebetween.

69. A method according to Claim 63 wherein forming the steering tube clamp comprises integrally forming a first clamp member with a side wall portion of the steering tube clamping portion.

70. A method for making a bicycle stem for connecting a bicycle handlebar to a bicycle steering tube, the method comprising:

forming a body portion having opposing first  
5 and second ends, a handlebar clamping portion connected to the first end of the body portion, and a steering tube clamping portion connected to the second end of the body portion, the steering tube clamping portion having a tubular shape defining a steering tube  
10 receiving passageway therethrough and a clamp receiving passageway therein transverse to the steering tube receiving passageway and in communication therewith;

forming a steering tube clamp for positioning  
in the clamp receiving passageway and comprising  
15 a pair of cooperating clamp members aligned in side-by-side relation and comprising respective portions defining a recess therein for the steering tube, the recess extending for greater than about 90  
20 degrees, and each clamp member having at least one fastener receiving passageway therein, and

at least one fastener extending between  
corresponding fastener receiving passageways  
25 of the pair of clamp members for urging the

clamp members together to engage the steering tube and thereby secure the bicycle stem to the steering tube.

71. A method according to Claim 70 wherein the recess extends for greater than about 120 degrees.

72. A method according to Claim 70 wherein the recess extends for greater than about 180 degrees.

73. A method according to Claim 70 wherein the body portion, handlebar clamping portion and steering tube clamping portion are integrally formed as a monolithic unit.

74. A method according to Claim 70 wherein the pair of clamp members each have a same shape.

75. A method according to Claim 70 further comprising forming a handlebar clamping member to cooperate with the handlebar clamping portion to clamp the bicycle handlebar therebetween.

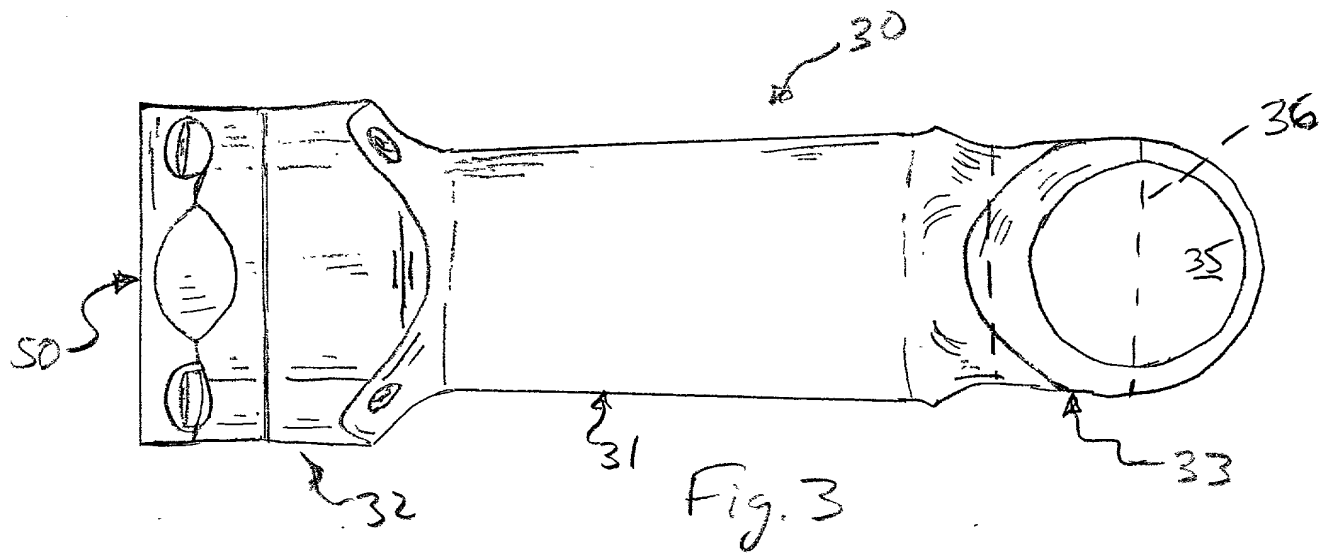
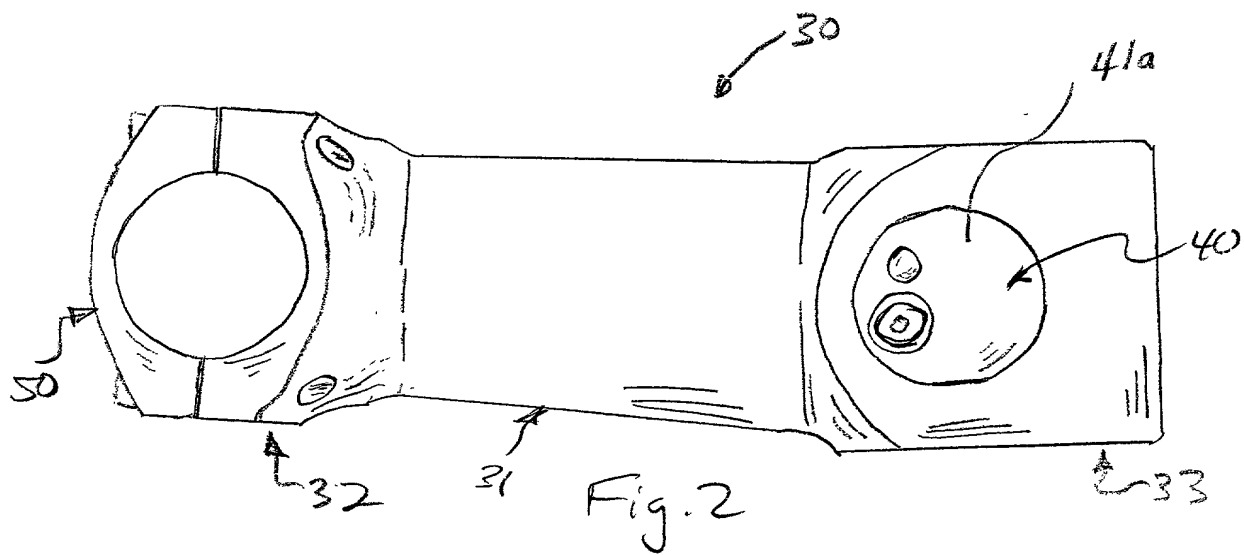
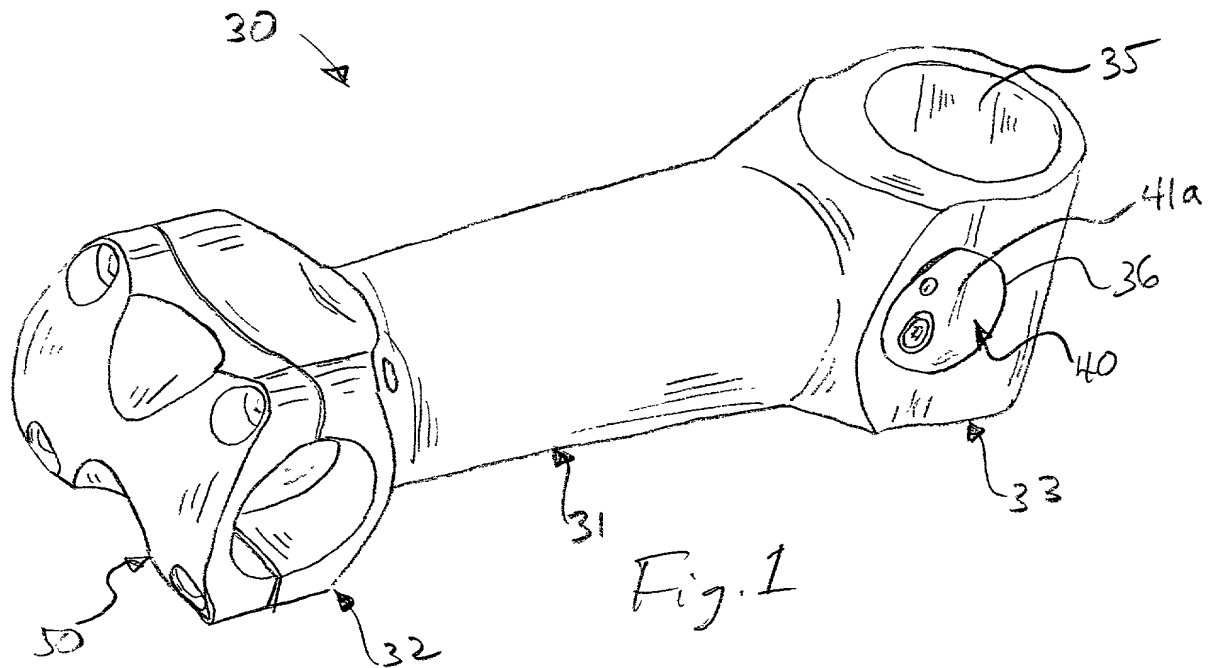
76. A method according to Claim 70 wherein forming the steering tube clamp comprises integrally forming a first clamp member with a side wall portion of the steering tube clamping portion.

**BICYCLE STEM INCLUDING ENHANCED CLAMP  
AND ASSOCIATED METHODS**

**Abstract of the Disclosure**

A bicycle stem includes a steering tube clamp with a pair of cooperating clamp members defining an imaginary cylinder and a recess therein for the steering tube. Each clamp member may also have at least one fastener receiving passageway therein offset a predetermined distance from an axis defined by the imaginary cylinder. The stem may include a body portion having opposing first and second ends, a handlebar clamping portion connected to the first end of the body portion, and a steering tube clamping portion connected to the second end of the body portion. The steering tube clamping portion may have a tubular shape defining a steering tube receiving passageway therethrough, and a clamp receiving passageway transverse to the steering tube receiving passageway and in communication therewith. The steering tube clamp may also include at least one fastener extending between corresponding fastener receiving passageways of the pair of clamp members for urging the clamp members together to engage the steering tube and thereby secure the bicycle stem to the steering tube. The at least one fastener may be a plurality of fasteners. The fastener receiving passageways may also be canted at a predetermined angle from parallel to the axis of the imaginary cylinder. The recess for the steering tube may also extend for greater than about 90 degrees.





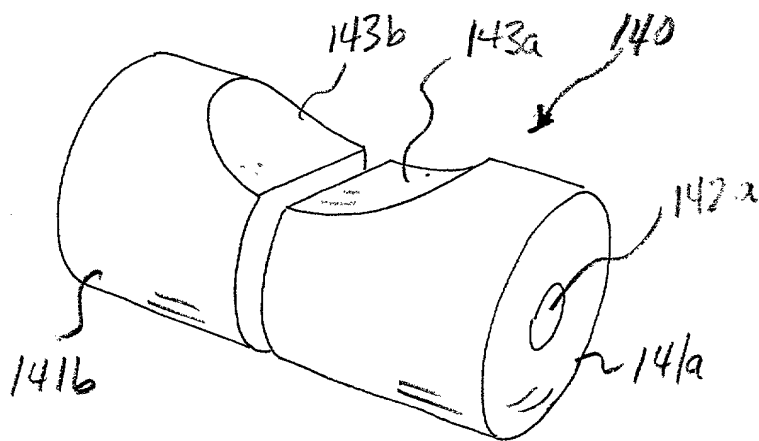


Fig. 4 (Prior Art)

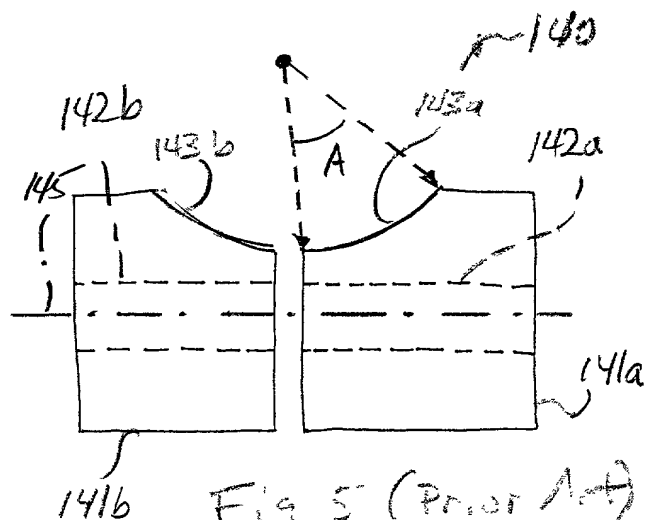


Fig. 5 (Prior Art)

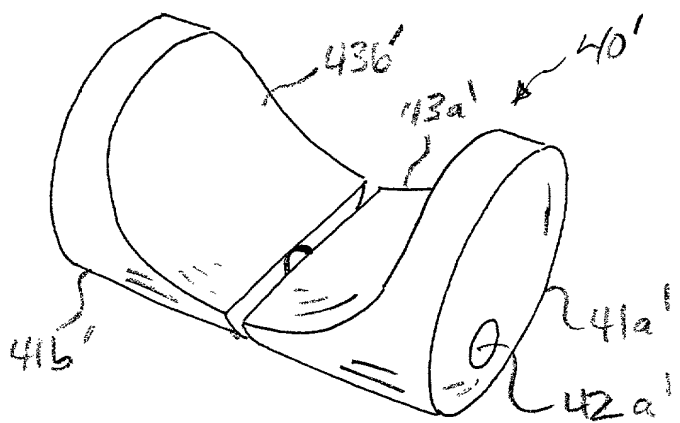


Fig. 6

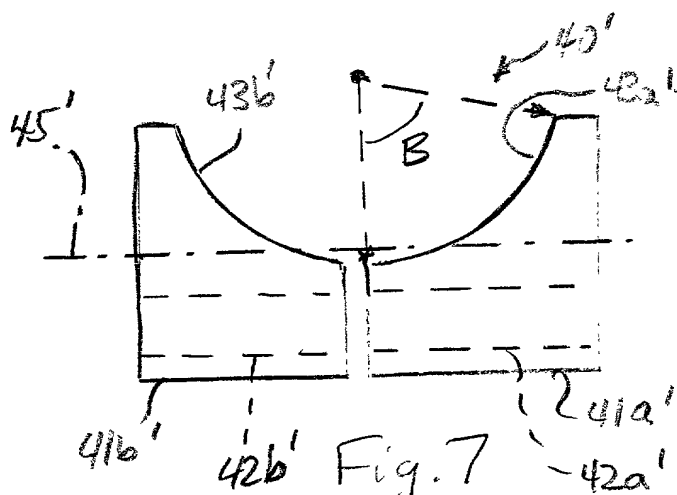


Fig. 7

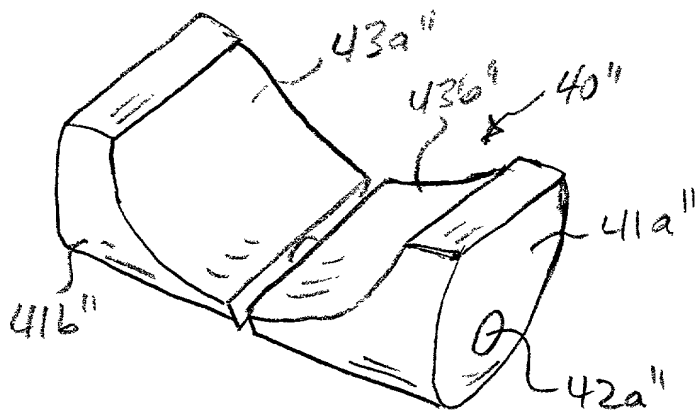


Fig. 8

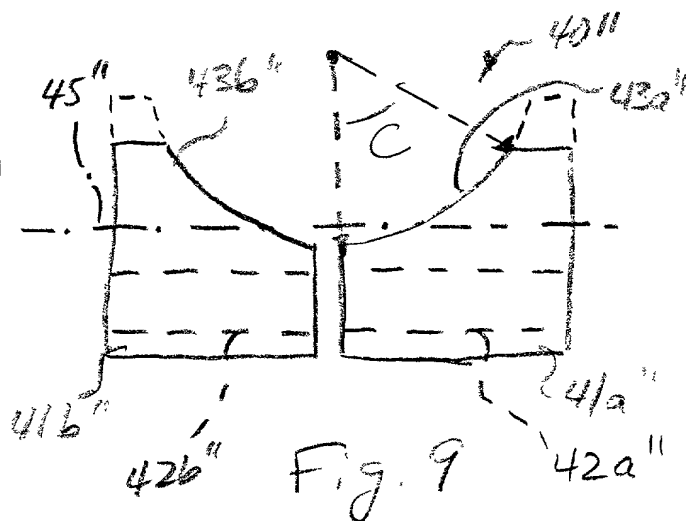
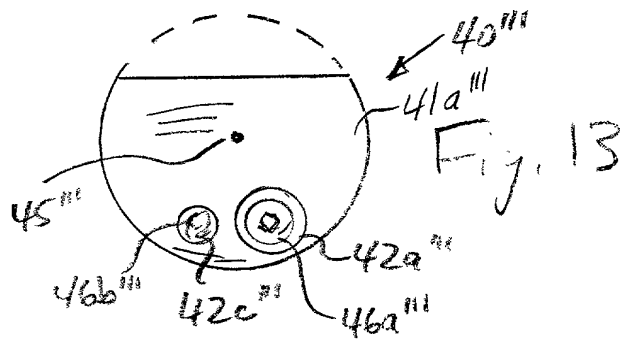
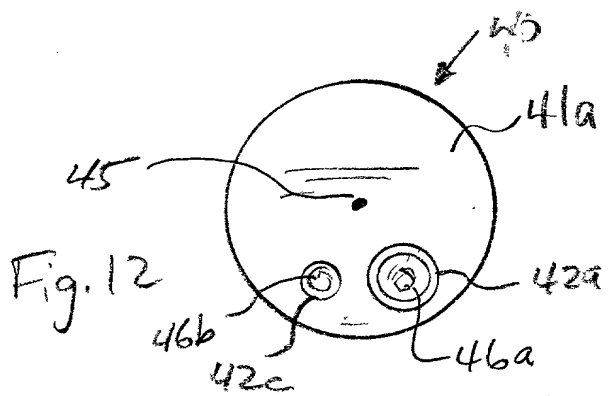
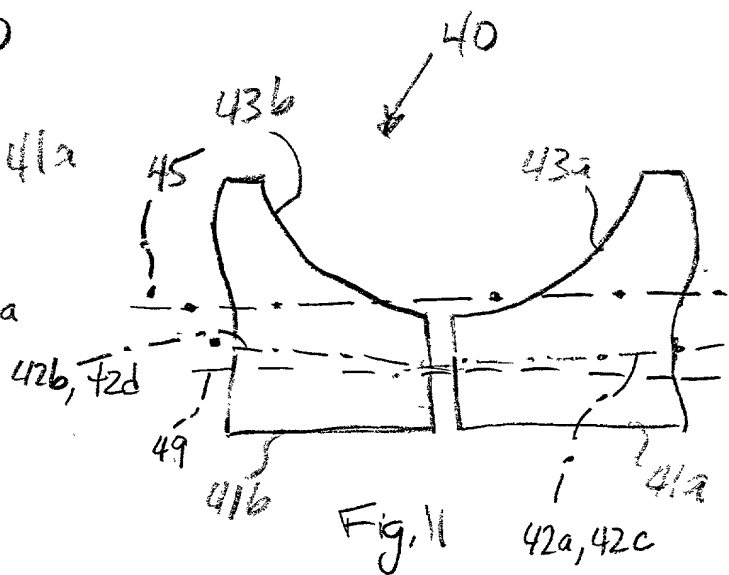
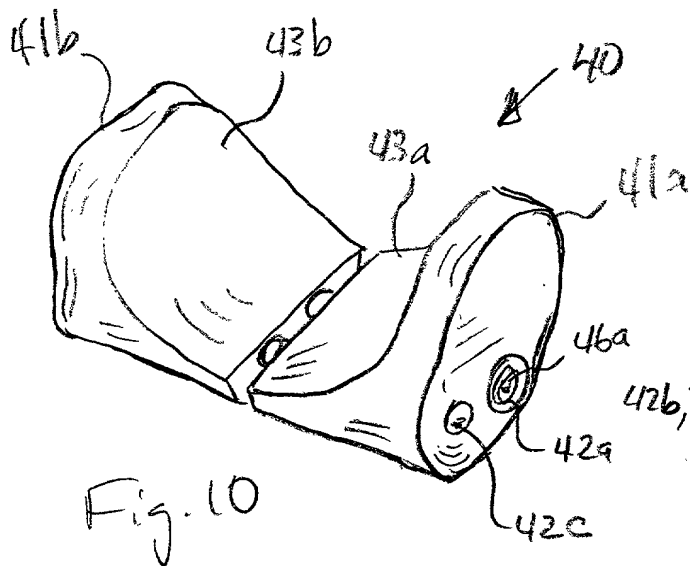
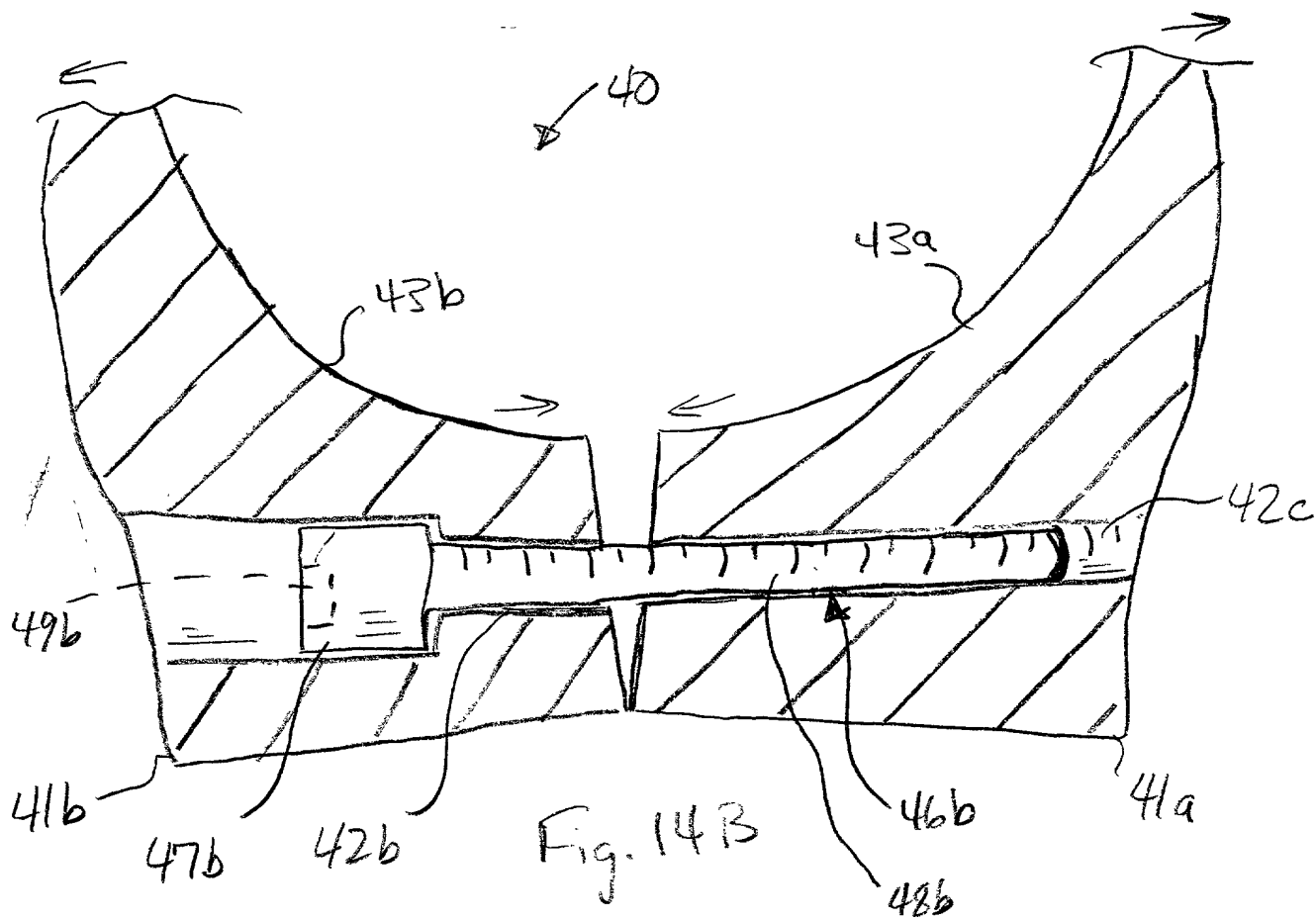
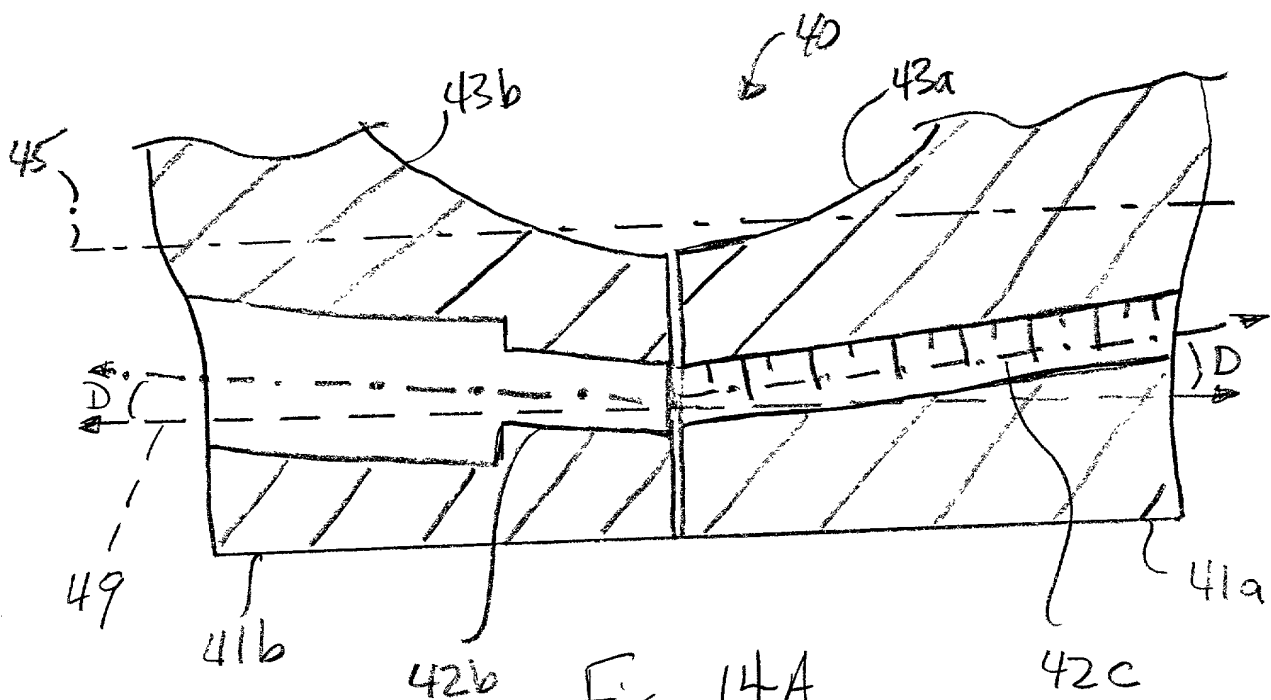
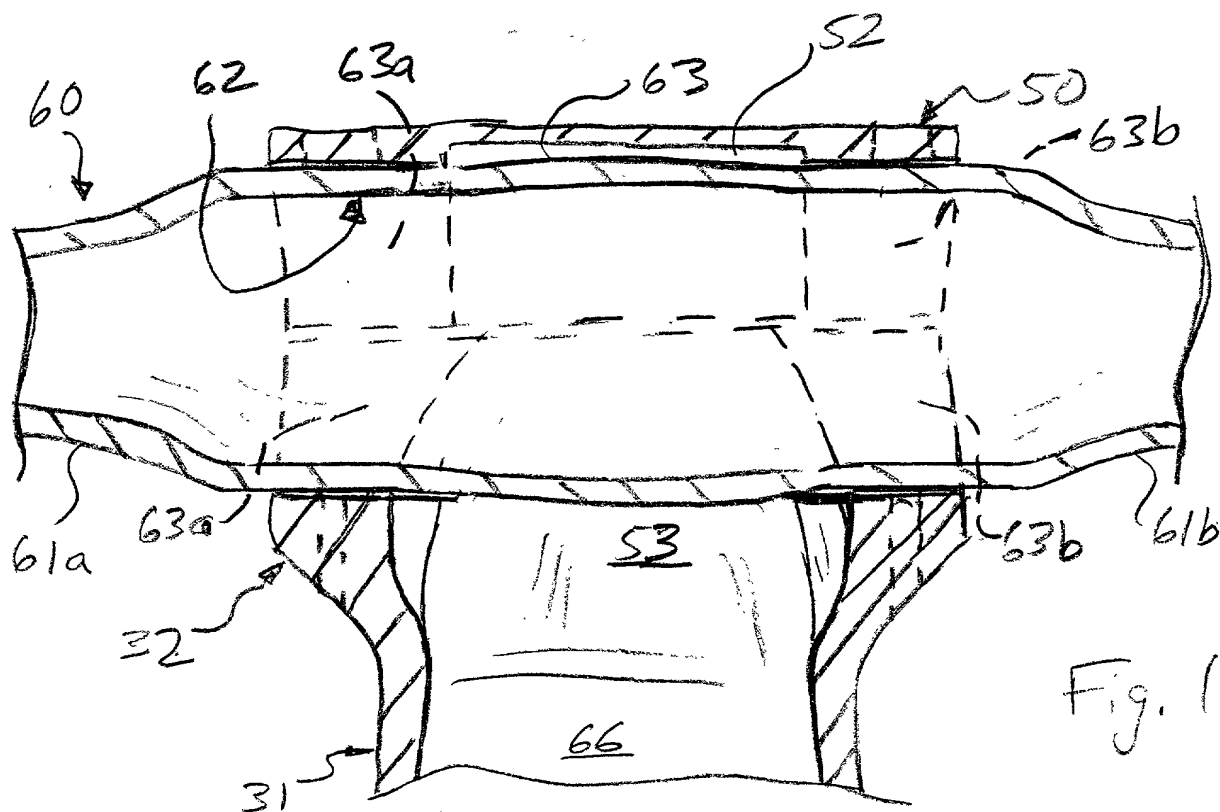
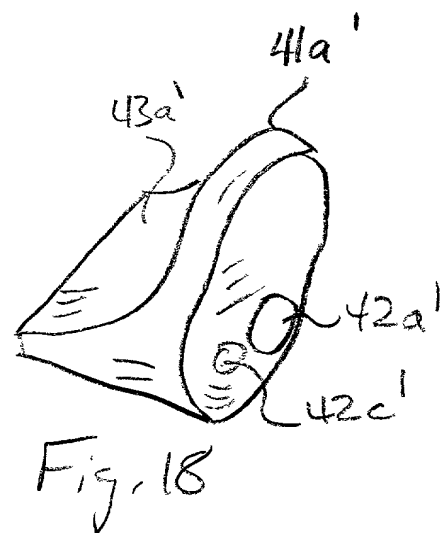
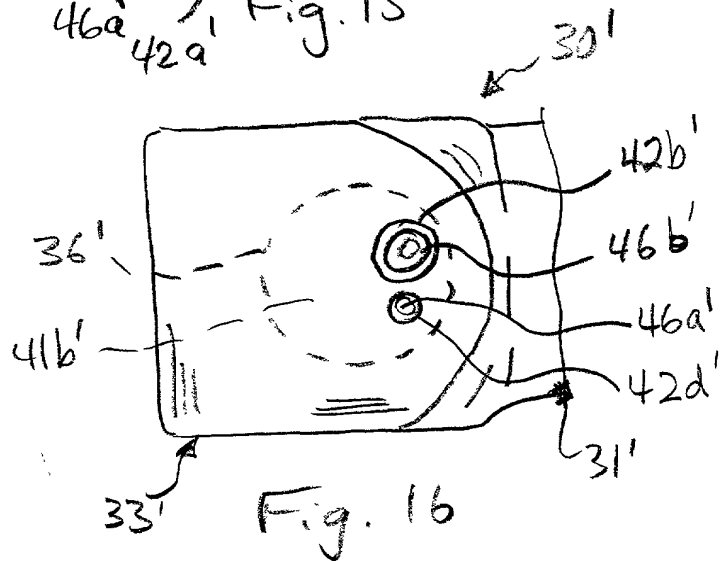
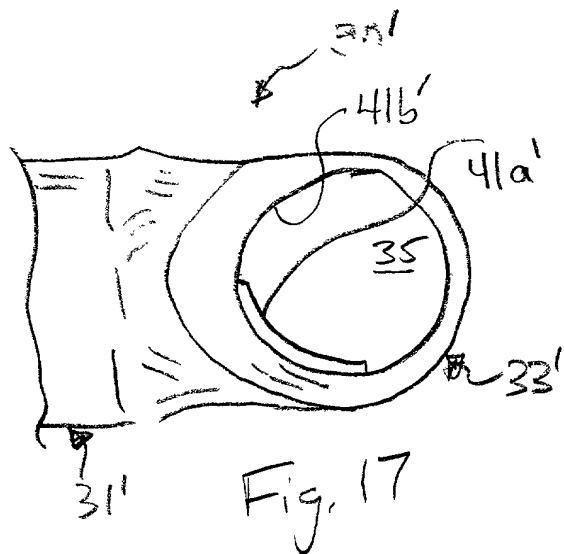
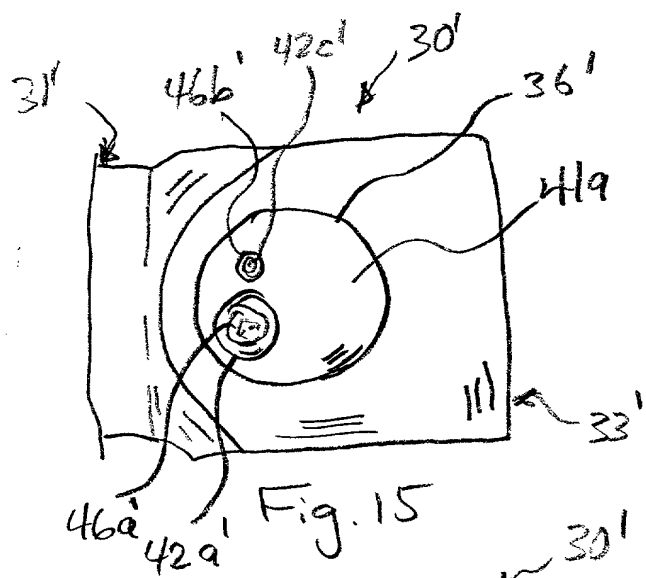
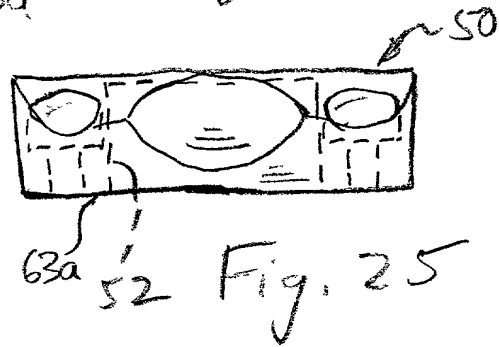
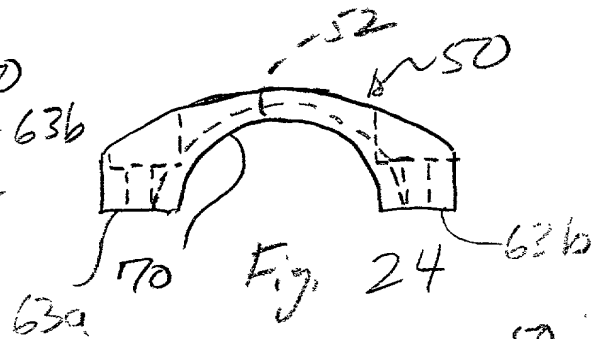
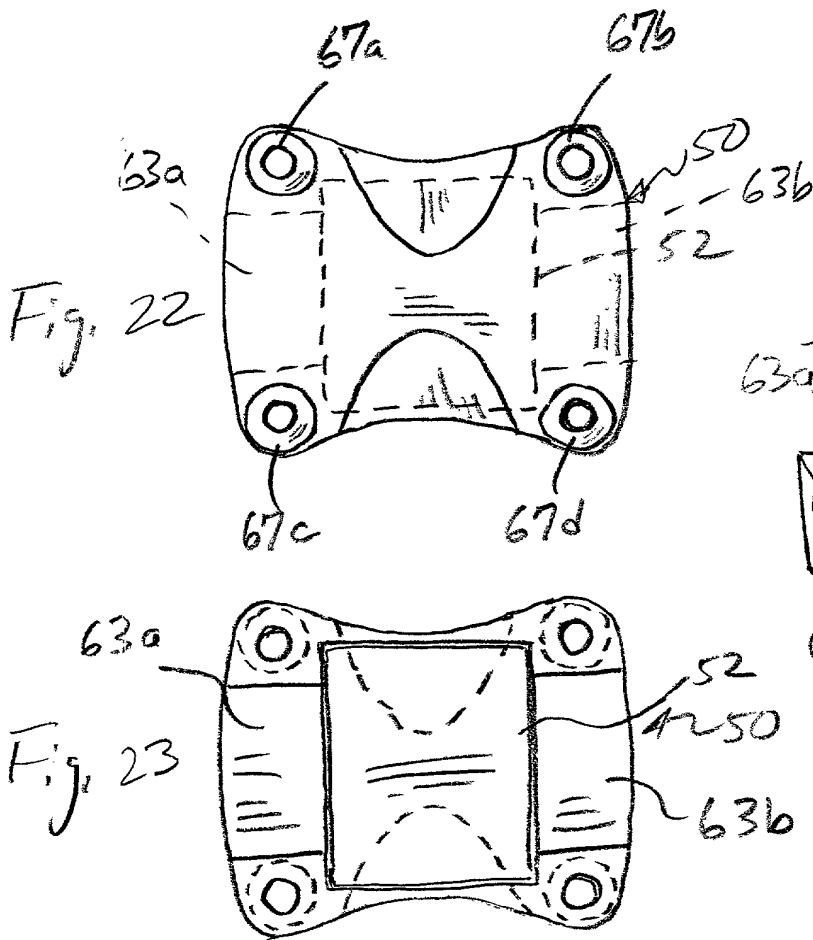
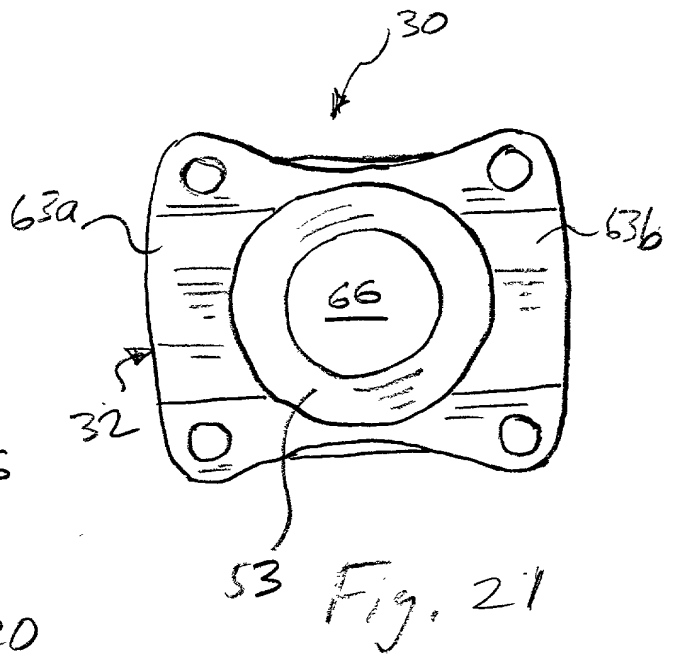
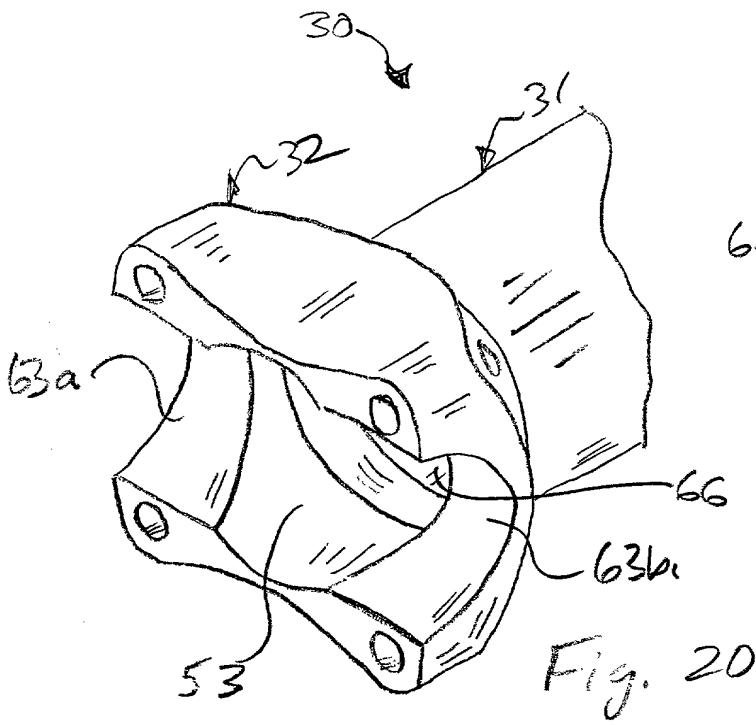


Fig. 9









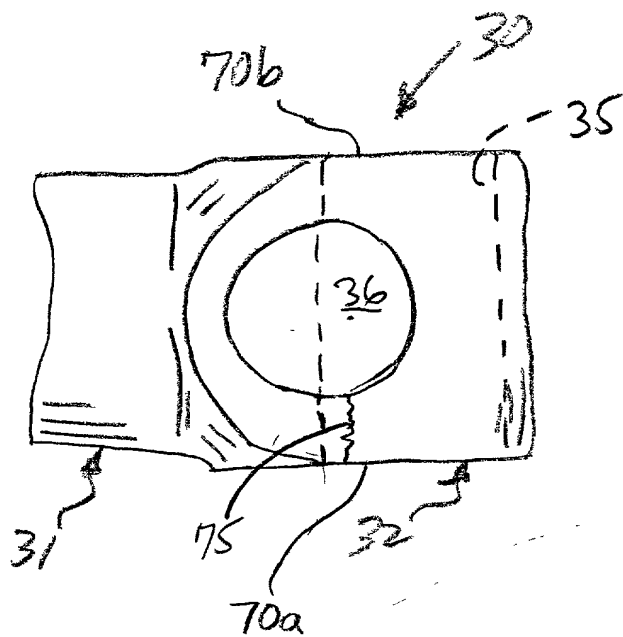


Fig. 26

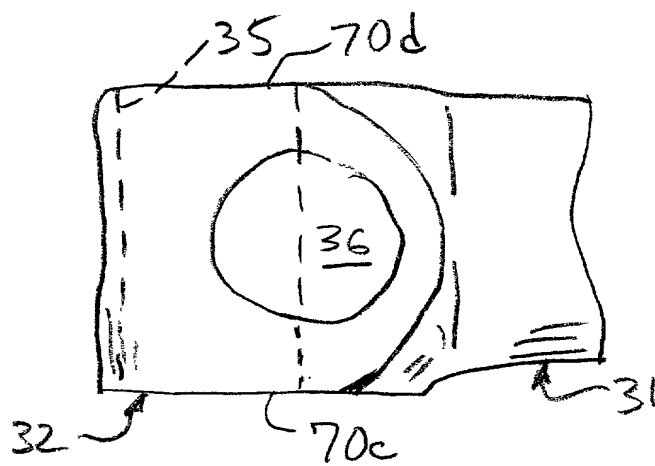


Fig. 27

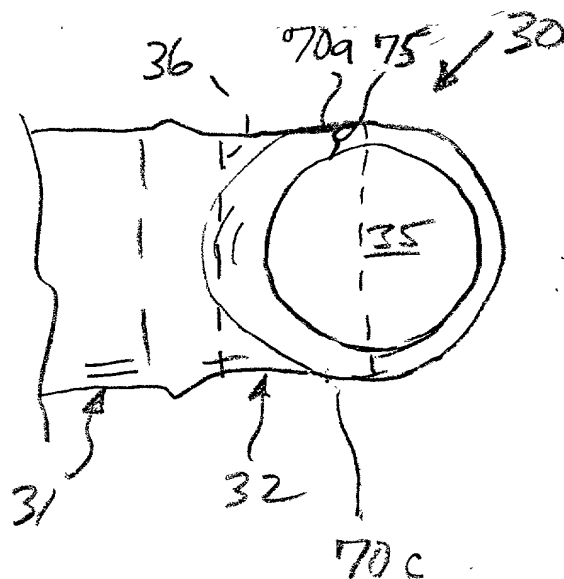


Fig. 28